

Work Order ID 81125-1

81125

March-08-12 8:54:52 AM

Item ID: D3560-043

Revision ID:

Item Name: Arm Weldment

Start Date: 08/03/2012 Start Qty: 6.00

Required Date: 22/03/2012 Req'd Qty: 6.00

Reference:

Approvals: Process Plan: *MLJ*

Date: 12/03/09 Tooling:

QC:

Date:

SPC (Y/N):

Cust Item ID:

Customer:

N9000040100

Setup Start *NS1*

Stop *NS2*

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3560	Rev D								
100	BAND SAW	0.00							
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blanks 15.500" long								
110	HAAS CNC VERTICAL MACHINING #1	0.00							
110									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1- Mill as per Folio FA695 Rev: <i>AA</i> & Dwg D3560 Rev: <i>D</i> 2-C'sink 0.196" hole on manual mill as per dwg D3560 3-Deburr per dwg D3560								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control									

*OK 12/04/01**B.A 12/04/08**12/04/10**B.A 12/04/08*

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

130

130

QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Memo

Set Up/
Run Hours

0.00

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

140

Large Fab

Large Fab

Large Fab

Memo

1-Weld assembly as per dwg D3560

STEP:

1- clean material (buff bracket and bottom of arm with blue pad)

2- set up bracket and arm on jig

3- preheat bracket and arm with torch

4- clean before welding with brush

5- set up machine to 135 amps

6- weld across bottom and top ends

7- reheat with torch (65 deg C)

8- on one side weld from bottom to top half way

9- same for other side (half way)

10- from half way point weld the rest of the first side (ease off pedal near end)

11- same for remaining side (ease off pedal near end)

near end)

Alum. Rod 120169

Accept

N9000040100

Setup Start

NS1

Stop

NS2

Run

Start

NR1

Stop

NR2

2 12.04.12

Work Order ID 81125

81125

March-08-12 8:54:52 AM

Item ID: D3560-043

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Revision ID:

Item Name: Arm Weldment

Start Date: 08/03/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 22/03/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

8/2/2013

22

243

160

QC9- Inspect visual per QSI004- Fusion Welds

0.00

160

QC

Memo

0.00

Quality Control

2 0 BE12/04/13

170

Chemical Conversion Coat per QSI005 4.1

0.00

170

HandFinish

Memo

0.00

Hand Finishing

2 0

Ae
12.04.16

Work Order ID 81125

81125

March-08-12 8:54:52 AM

Item ID: D3560-043

Revision ID:

Item Name: Arm Weldment

Start Date: 08/03/2012 Start Qty: 6.00

Required Date: 22/03/2012 Req'd Qty: 6.00

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

180

QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

2

φ

rl
12-04-16

190

190

Small Fab

Small Fab

Small Fab

Memo

1-Press bushing in D3560 arm per dwg D3562

0.00

0.00

2

φ

SP 12/04/16

200

200

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Si 7/4/16

2

273

210

Identify as per dwg & stock UIR

2

0

rl
12-04-16

Work Order ID 81125

March-08-12 8:54:52 AM

81125

Page 5

Item ID: D3560-043

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Arm Weldment

Start Date: 08/03/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 22/03/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Run

Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

Identify as per dwg & Stock Location: WNA

0.00

210

Packaging

Memo

0.00

Packaging

*** STOCK IN STEP CELL***

2

φ

12-04-17

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

12/4/18

WNA

12-04-17

Picklist Print

March-08-12 8:54:56 AM

Work Order ID: 81125

81125

Parent Item: D3560-043

D3560-043

Parent Item Name: Arm Weldment

Start Date: 08/03/2012

Required Date: 22/03/2012

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A New Issue 07.05.24 EC
 IPP Rev B ECN 987 07.10.09 EC
 IPP Rev:C ECN1048 07-12-18 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2808		Manufactured	No			100	Each	35.0000	1	6			
**													
D2808													
Bushing													
						<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>				
						GA		35					
						32896		2					
						79688		33					
M6061T6B0.500X05.00		Purchased	No			140	f	75.2274	1.295	8.178947			
**													

M6061T6B0 500X05 000

6061-T6 Bar .500 x 5.00

<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>
MAT001		21.834	
112154		6.935	
117933		2.123	
119346		12.776	
MAT004		53.3934	
120243		24	
120421		5.3934	
120866		24	

19121040 x 8.18

12/04/01

Picklist Print

March-08-12 8:54:56 AM

Work Order ID: 81125

81125

Parent Item: D3560-043

D3560-043

Parent Item Name: Arm Weldment

Start Date: 08/03/2012

Required Date: 22/03/2012

Start Qty: 6.00

Required Qty: 6.00

D3592-1

Manufactured No

190

Each

17.0000

1

6

**

*12.04.12****D3592-1***

Plate

LocationLoc QtyLoc Code

WA

15

79715

15

WA002

2

47015

2

2

FIRST ARTICLE INSPECTION CHECKLIST

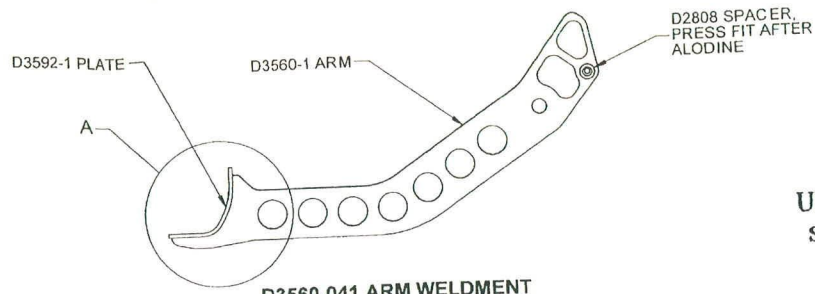
Measured by: B.A. AD		Audited by: OK		Preliminary Approval:	
Date: 12/04/08		Date: 12/04/10		Date:	
12-04-10					

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

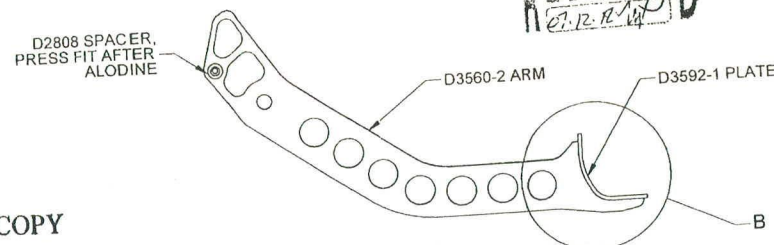
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03.12.2014

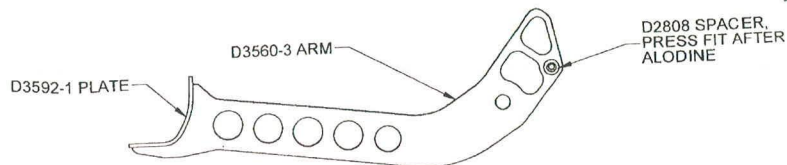
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81125 MLJ
12/03/09



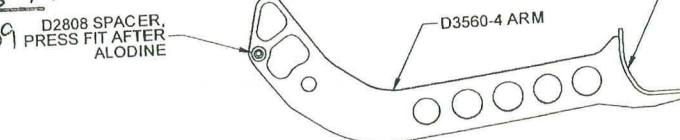
D3560-041 ARM WELDMENT



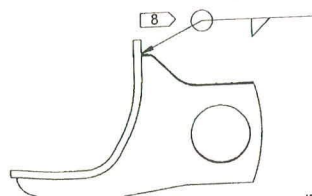
D3560-042 ARM WELDMENT



D3560-043 ARM WELDMENT



D3560-044 ARM WELDMENT



DETAIL A
SCALE 1:2

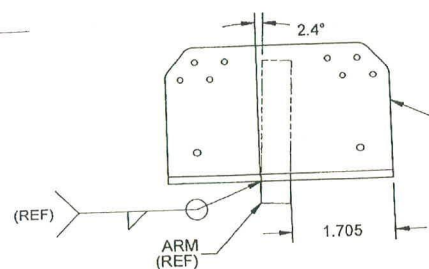
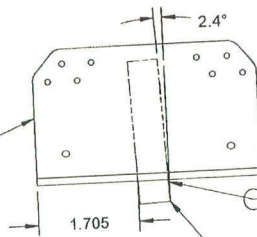
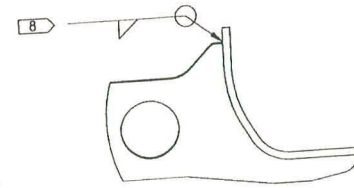


PLATE
(REF)



ARM
(REF)



DETAIL B
SCALE 1:2

PARTS LIST

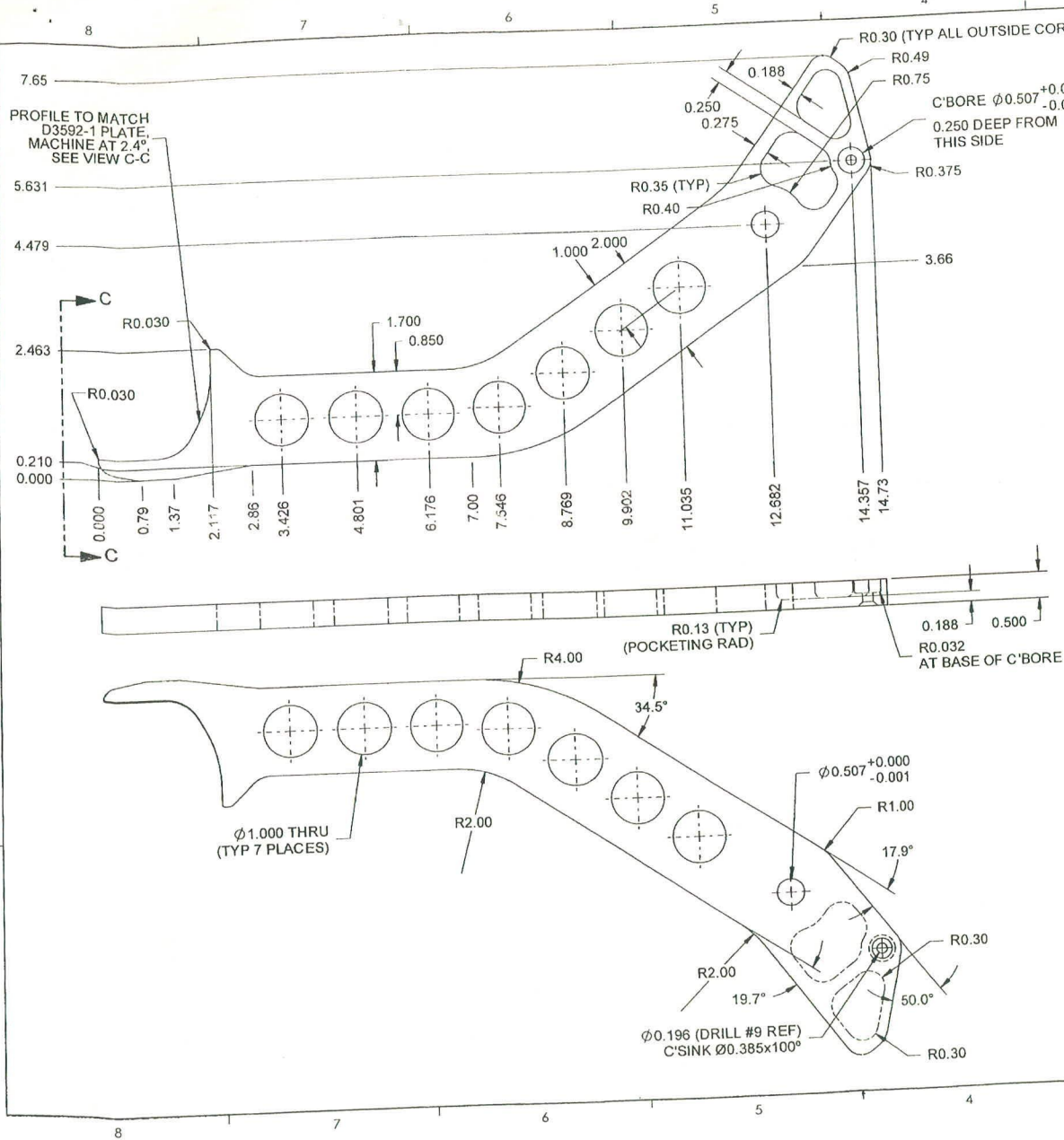
QTY -041	QTY -042	QTY -043	QTY -044	P/N	DESCRIPTION
X	X			D3560-041	ARM WELDMENT
		X		D3560-042	ARM WELDMENT
			X	D3560-043	ARM WELDMENT
				D3560-044	ARM WELDMENT
1	1	1	1	D2808	SPACER
1				D3560-1	ARM
	1			D3560-2	ARM
		1		D3560-3	ARM
			1	D3560-4	ARM
1	1	1	1	D3592-1	PLATE

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.23 lbs (TYP)
- 8) WELDING: PER DART QSI 004

REV.	DESCRIPTION	DC	DATE
D	ADD D2808 PRESS FIT NOTE; REDRAWN IN SOLIDWORKS	CP	07.11.16
C	REMOVE POWDER COAT	CP	07.06.19
B	REDESIGN AS WELDMENT, ADD POCKETS	CP	07.01.15
A	NEW ISSUE	CP	06.09.25
		BY	DATE

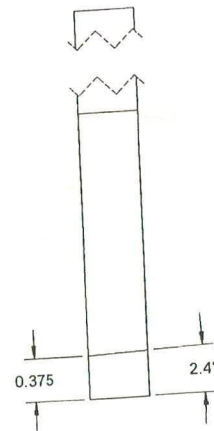
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CHECKED		D3560	SHEET 1 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		ARM WELDMENT	1:4
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DATE	07.11.16		



81125

D3560-1 ARM WELDMENT

- NOTES:
 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 (REF. DART SPEC. M6061T6B0.500)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 1.05 lbs



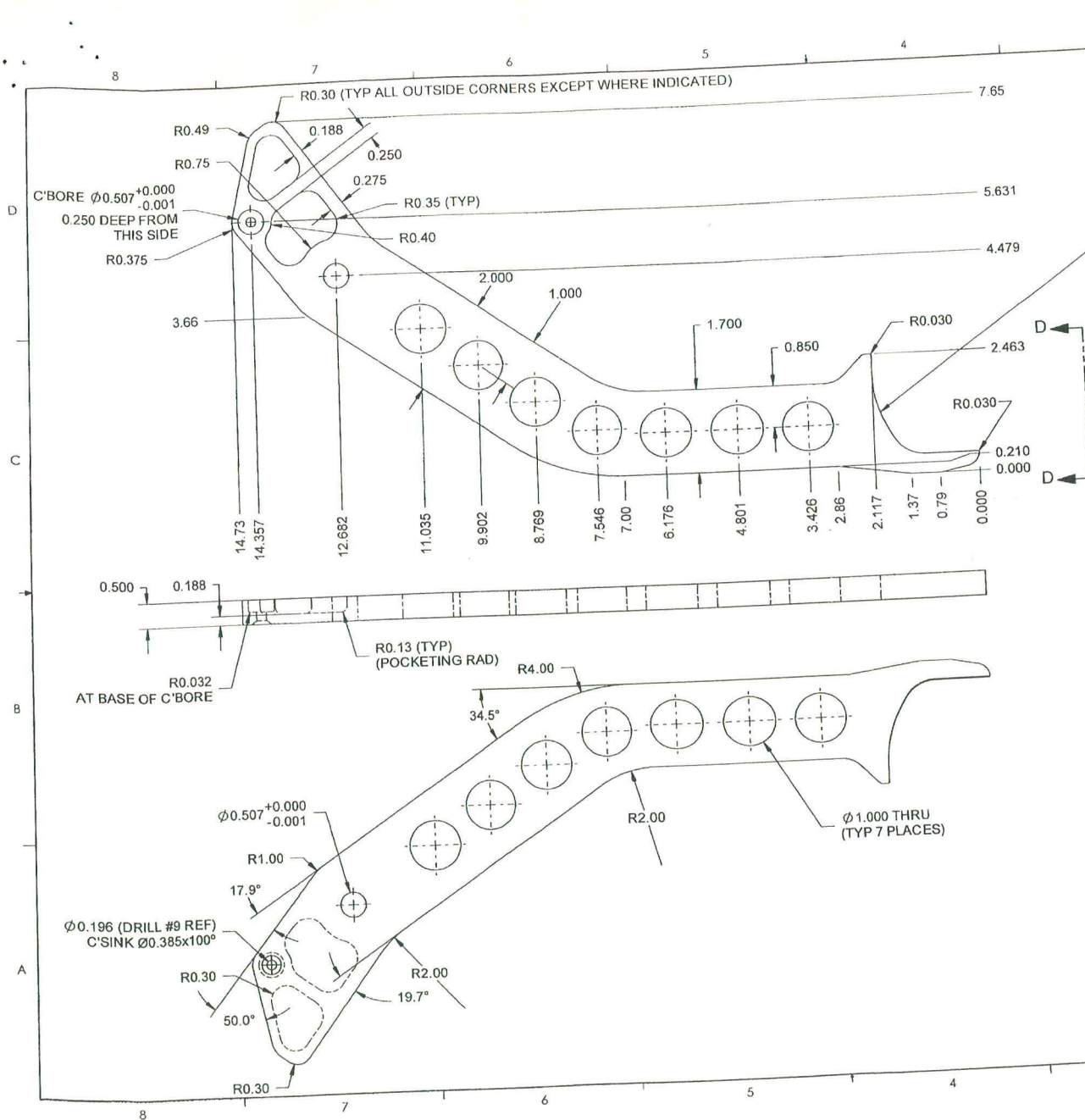
VIEW C-C
SCALE 1:1

RELEASED
07.12.14

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DRAWN	JC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. D
MFG. APPR.	JP	D3560	SHEET 2 OF 5
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	ARM WELDMENT	1:2
DATE	07.11.16	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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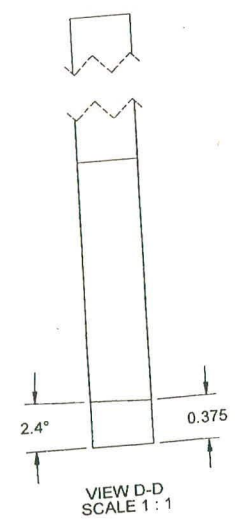
RELEASED
11/27/12



PROFILE TO MATCH
D3592-1 PLATE,
MACHINE AT 2.4°,
SEE VIEW D-D

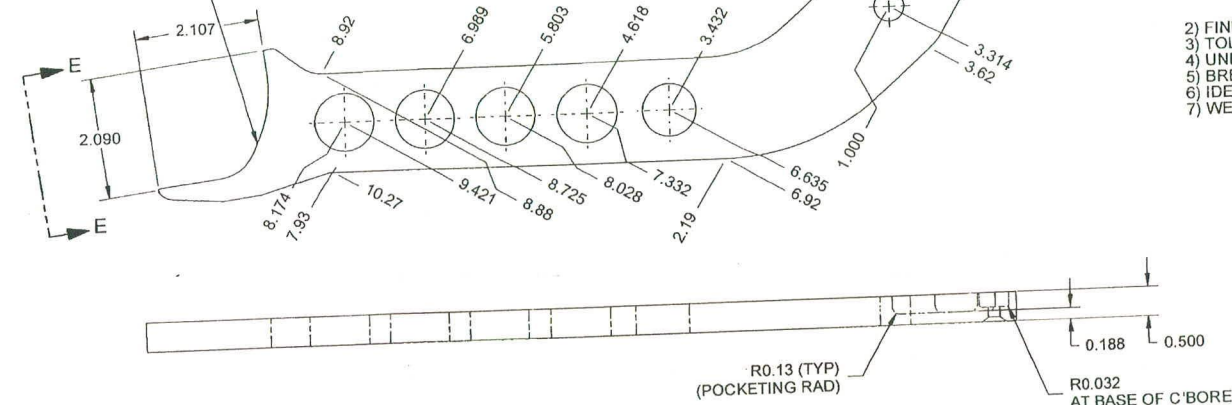
D3560-2 ARM

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B0.500)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.05 lbs



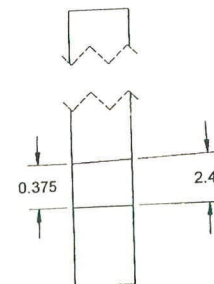
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DRAWN	QC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	QC	DRAWING NO.	REV. D
MFG. APPR.	QC	D3560	SHEET 3 OF 5
APPROVED	QC	TITLE	SCALE
DE APPR.	QC	ARM WELDMENT	1:2
DATE	07.11.16	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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PROFILE TO MATCH
D3592-1 PLATE,
MACHINE AT 2.4°
SEE VIEW E-E



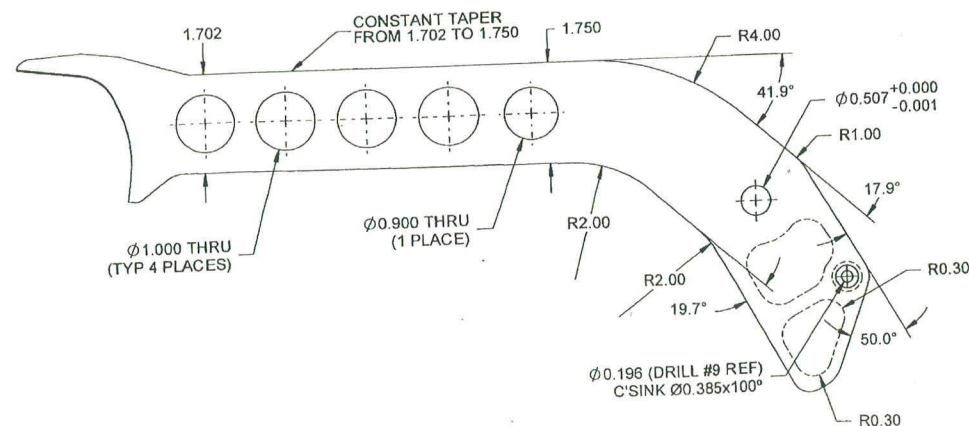
D3560-3 ARM

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B0.500)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.05 lbs



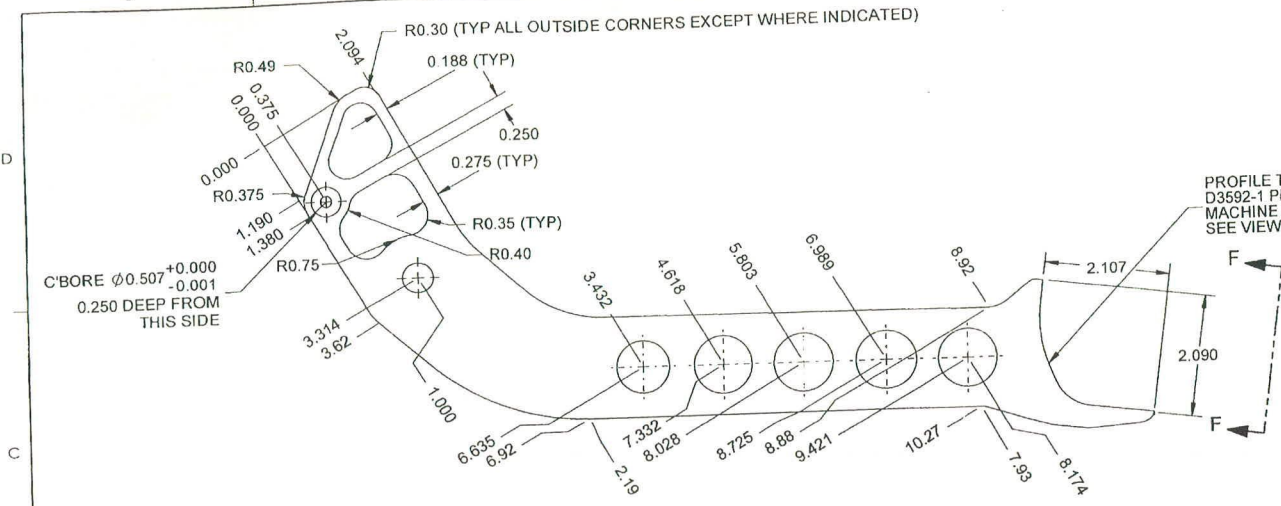
VIEW E-E
SCALE 1 : 1

RELEASED
07.12.18 11:00



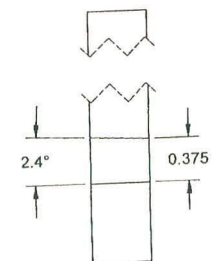
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DRAWN	AC		SHEET 4 OF 5
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MFG. APPR.	MP		1:2
APPROVED	MP		
DE APPR.	AS		
DATE	07.11.16		

81125

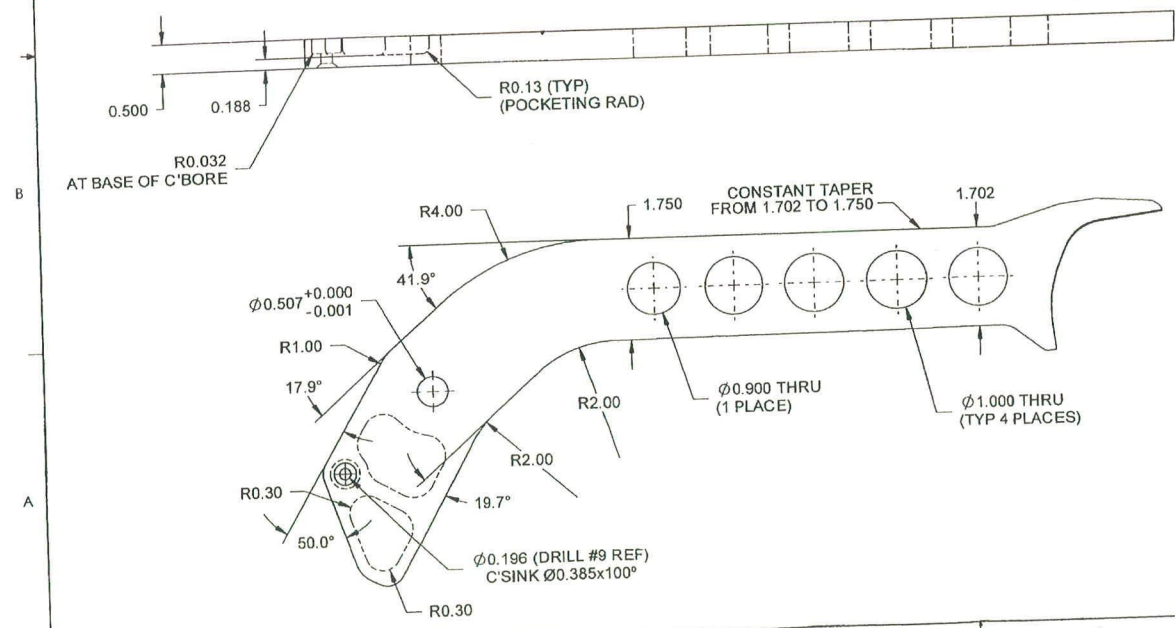


D3560-4 ARM

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6511/T62) BAR, 0.500 THICK
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B0.500)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.05 lbs



VIEW F-F
SCALE 1:1



DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3560	SHEET 5 OF 5
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